

Date: Monday, 9/10/2007 1:32:16 PM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACER
Job Number : 34525	
Estimate Number : 11167	
P.O. Number : <i>N/A</i>	Part Number : D32783
This Issue : 9/10/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3278 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 34024	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 9/21/2007 Qty: 40 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est. A 04.04.19 New issue KJ/JLM Est B 07.09.06 Rev C dwg EC Verified by: JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MDELRS0125	Black Delrin Sheet .125
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Comment: Qty.: 0.0361 sf(s)/Unit Total : 1.4448 sf(s)  
Black Delrin  
~~Use DT8685 Router Table.~~ *N/A*  
Material: Black Delrin/UHMW 0.125" thick  
(M-DELIN-S0.125x30.0)  
Identify for D3278-3  
Batch: *M15607* *B 07-09-19*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
1-Cut as per Dwg D3278  
Dwg Rev: *C* *B 07-09-19*  
Prog Rev: *C*  
  
2-Deburr if necessary

*(44)*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*no 02/09/19*

*(44)*

*counter*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/10/05  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 9/10/2007 1:32:16 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 34525

Part Number: D32783

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-C'sink as per dwg D3278

*\* make sure clean (no scratches) is part of \**

2-Deburr

*mf 07-10-03*

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*counter*  
*U 07/10/03* **(44)**

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *GA*

*mf 07/10/04*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

**(44)**  
*07/10/05*

Job Completion



*U 07-10-05*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

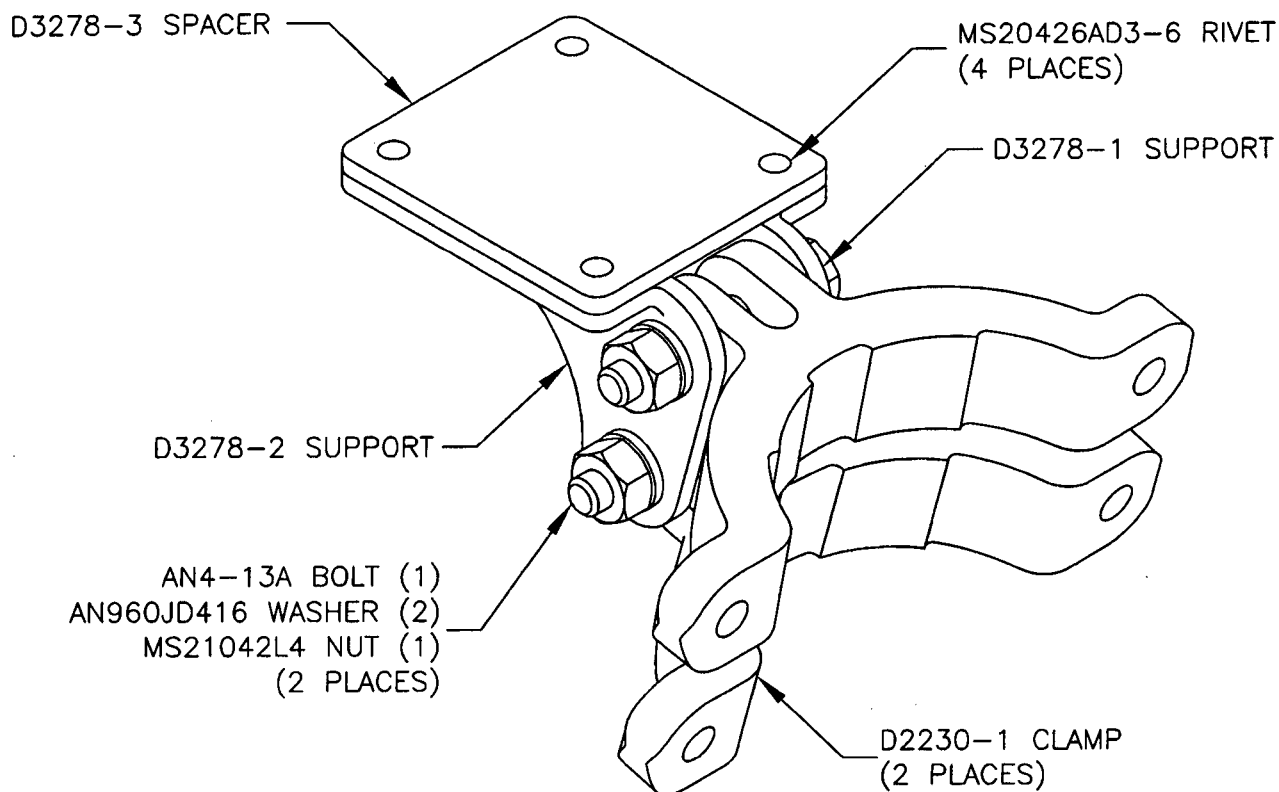


**DART**

DESIGN <i>GP</i>	DRAWN BY <i>SC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24	TITLE SUPPORT ASSEMBLY		SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

**RELEASED**  
07 08 08

## D3278-041 SUPPORT ASSEMBLY



Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

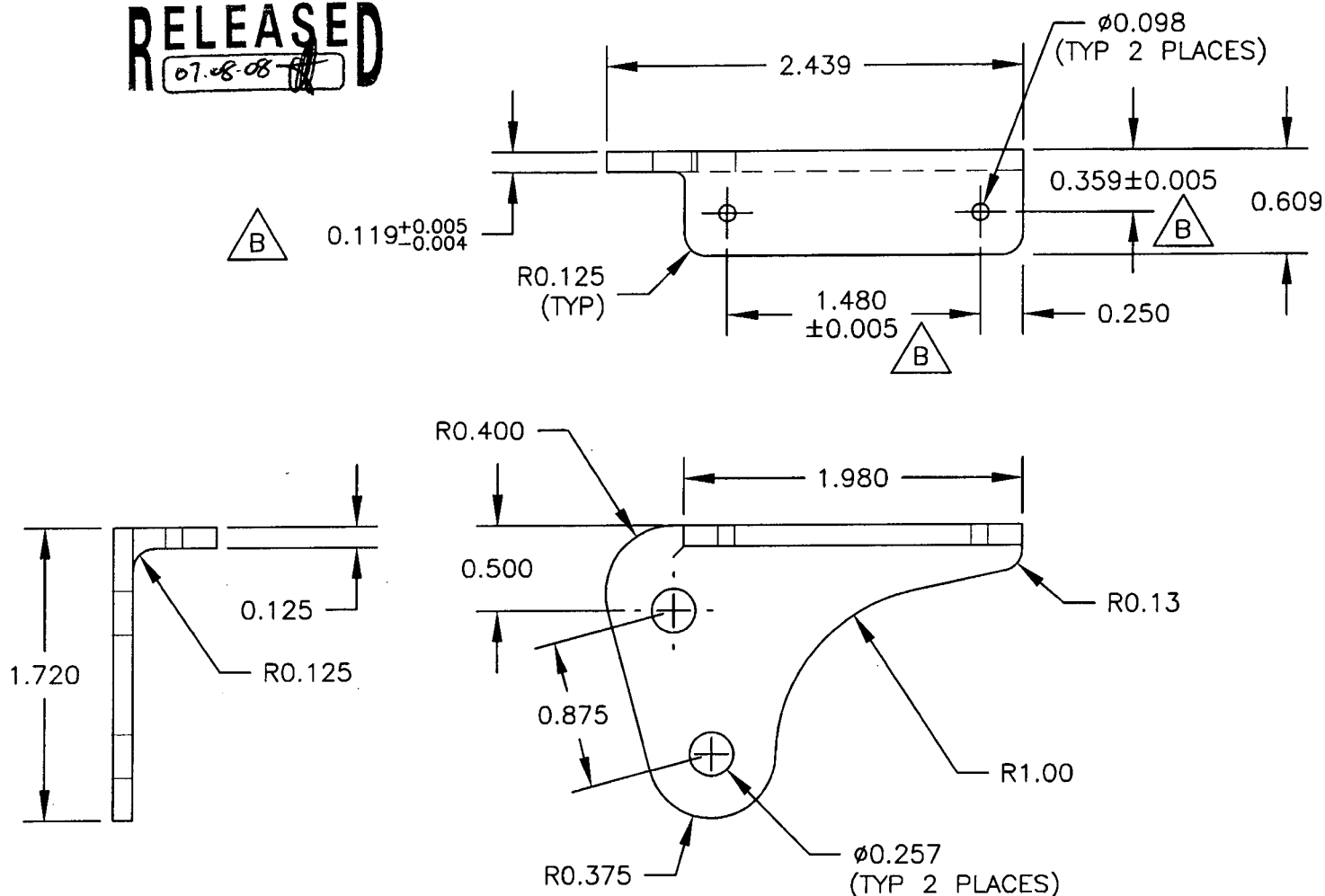
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**DART**

DESIGN <i>gp</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24	TITLE SUPPORT ASSEMBLY		SCALE 1:1

**RELEASED**  
07.08.08**D3278-1 SUPPORT (SHOWN)****D3278-2 SUPPORT (OPPOSITE)**

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRJT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

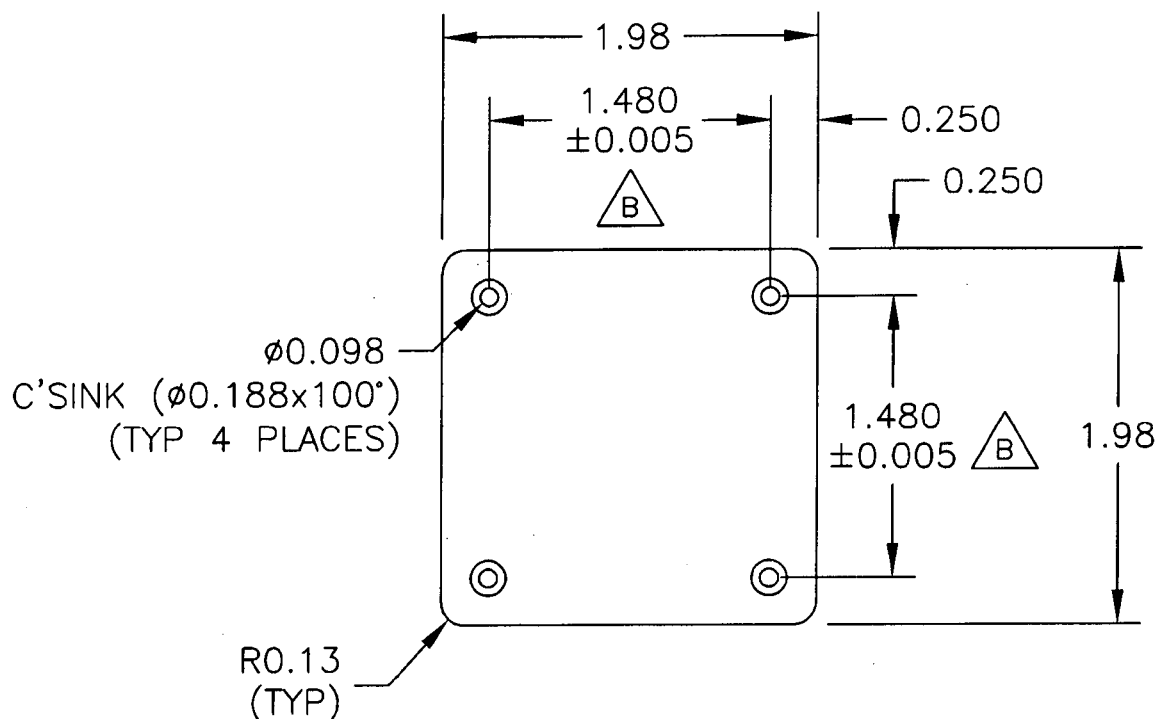
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**DART**

DESIGN 901	DRAWN BY BC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24	TITLE SUPPORT ASSEMBLY		SCALE 1:1

**RELEASED**  
07.08.08**D3278-3 SPACER**

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL  
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR  
DELRIN II 150E OR ACETRON GP ACETAL  
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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